

Date: Tuesday, 15/07/2008 9:14:06 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR DOUBLER
Job Number	: 40476		
Estimate Number	: 12681		
P.O. Number	:	Part Number	: D3594043
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3594 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 39575	Material	:
Written By	:	Due Date	: 30/07/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.15.28</u>		
Comment	: Est Rev :A New Issue 07-01-22 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)

6061-T6 .080 Sheet

Batch: 108433 FB 8-8-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

FB 8-8-12

(13)

2-Deburr if necessary

FB 8-8-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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FB 8-8-12



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/12 (13)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

FB 08/08/12 (13)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:14:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 40476

Part Number: D3594043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (13)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M/F2

08/08/20

(13)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A

08/08/20

(13)

9.0	MS210695	Anchor nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Anchor nuts

BATCH: 110 7938

EP 08/08/20

10.0	MS20426AD44	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

BATCH: 11021

EP 08/08/20

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

EP 08/08/20 (13)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (13)

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST248

KS 08/08/20 x13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:14:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 40476

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

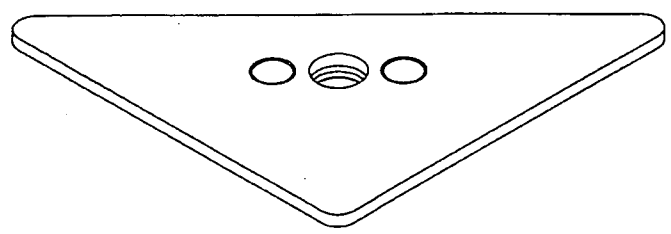
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QA: N/C Closed: _____ Date: _____

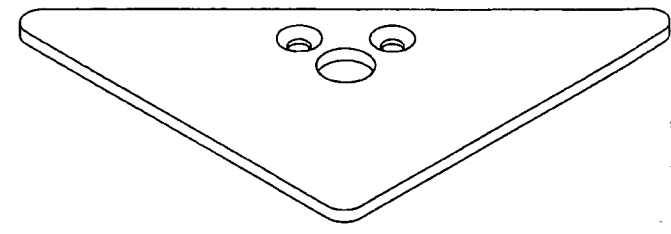
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

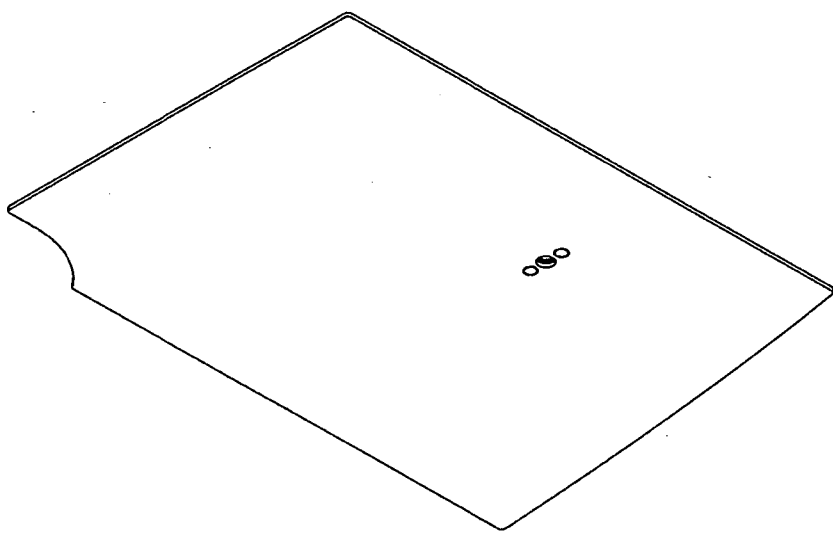
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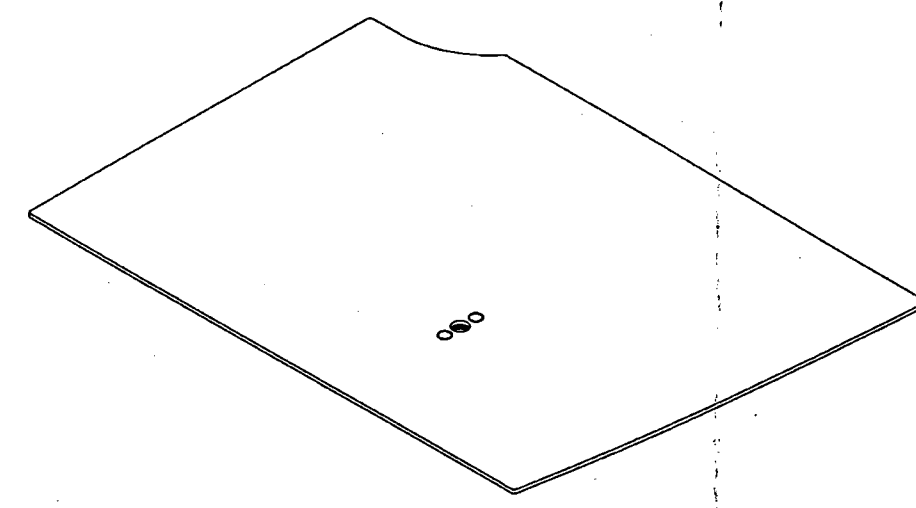
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

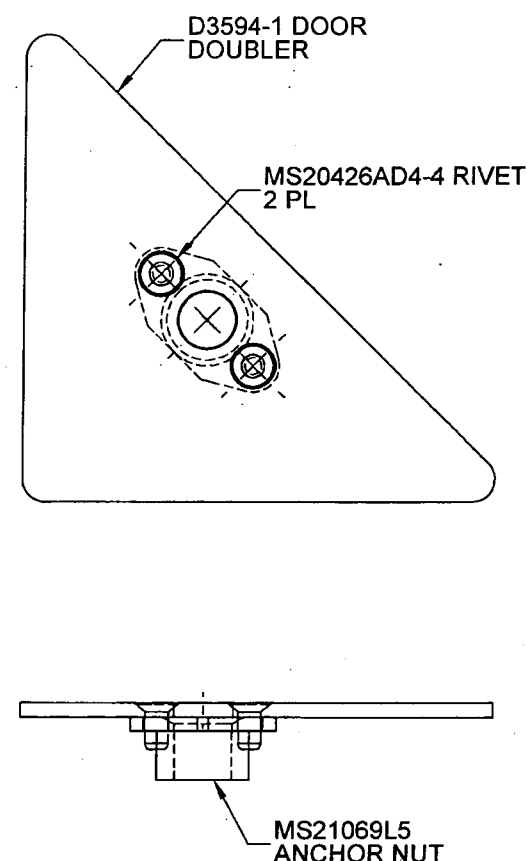
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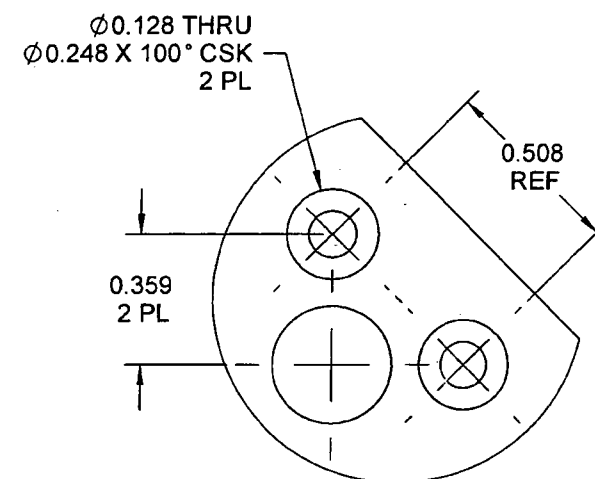
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.		AJS	08.05.14
A	NEW ISSUE		MB	07.04.13
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO. D3594		REV. B
MFG. APPR.				SHEET 1 OF 4
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DE APPR.				NTS
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8 7 6 5 4 3 2 1

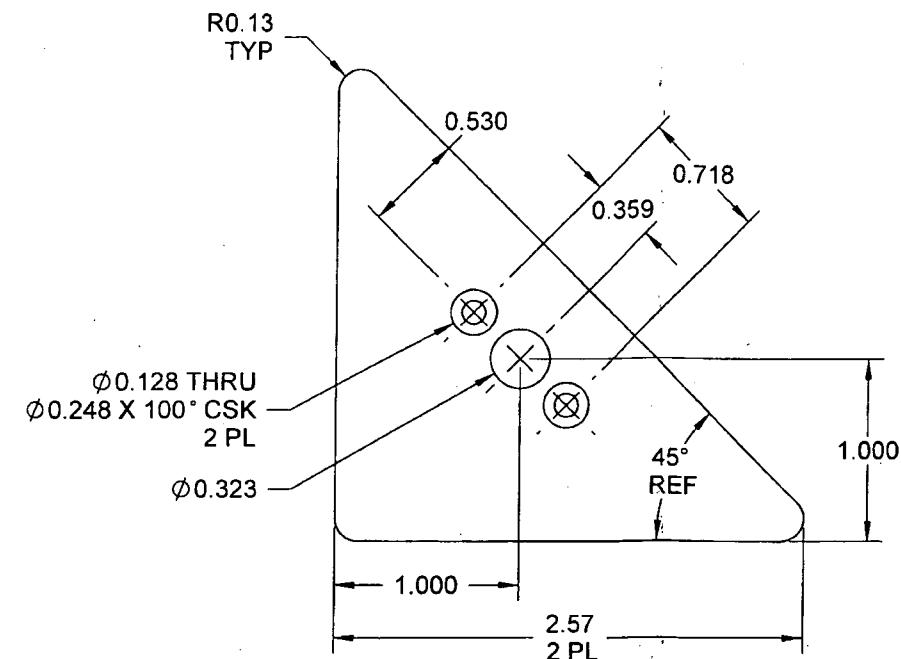
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



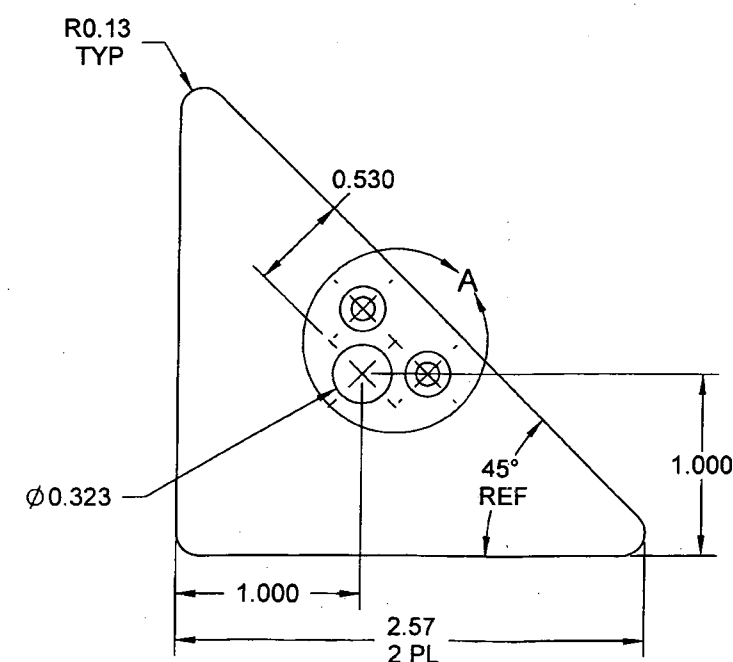
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X







D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

NOTES:

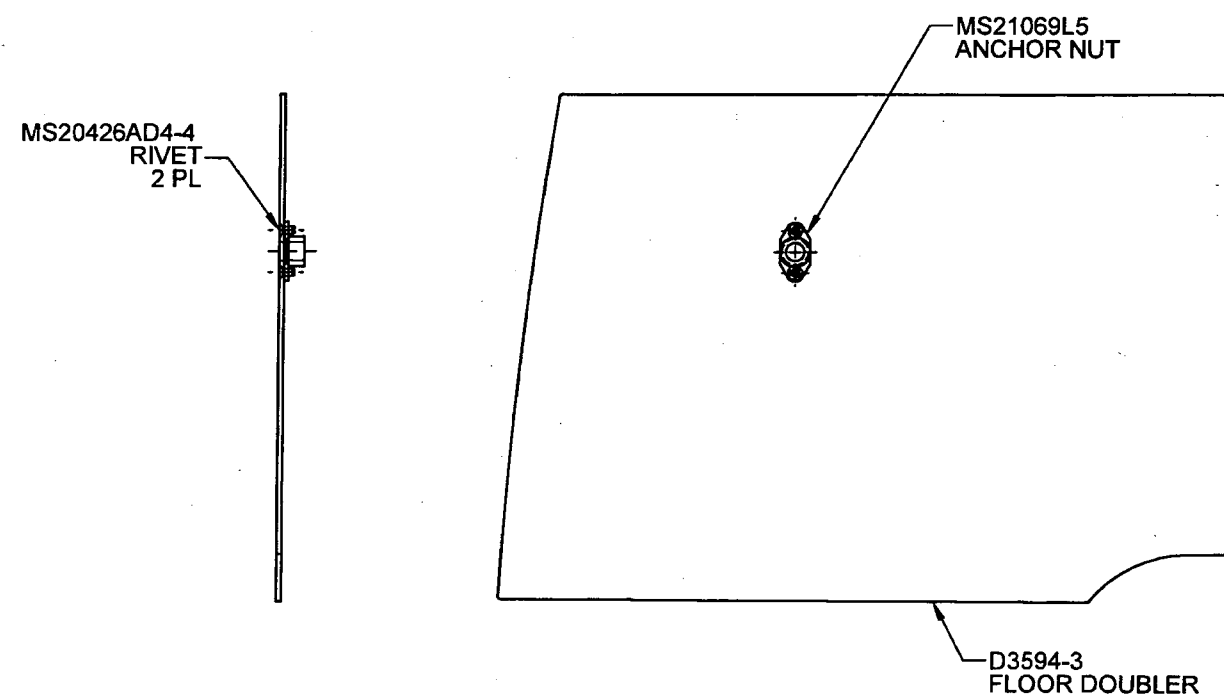
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
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MFG. APPR.		D3594	SHEET 2 OF 4
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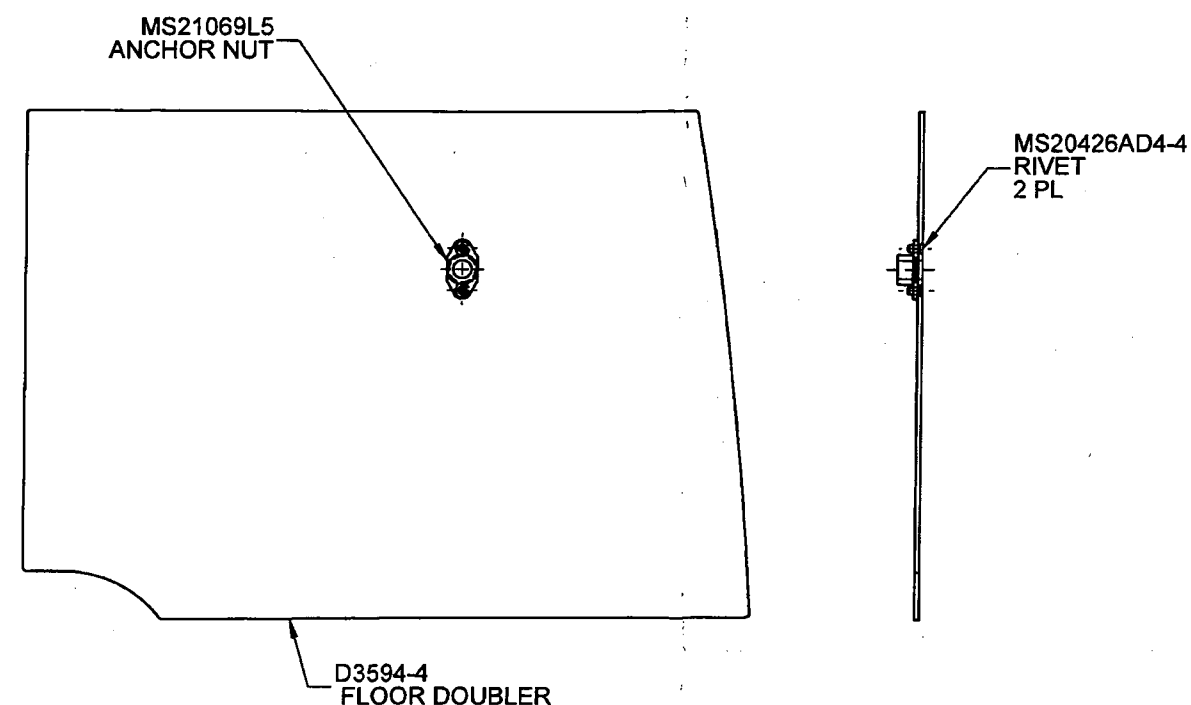
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



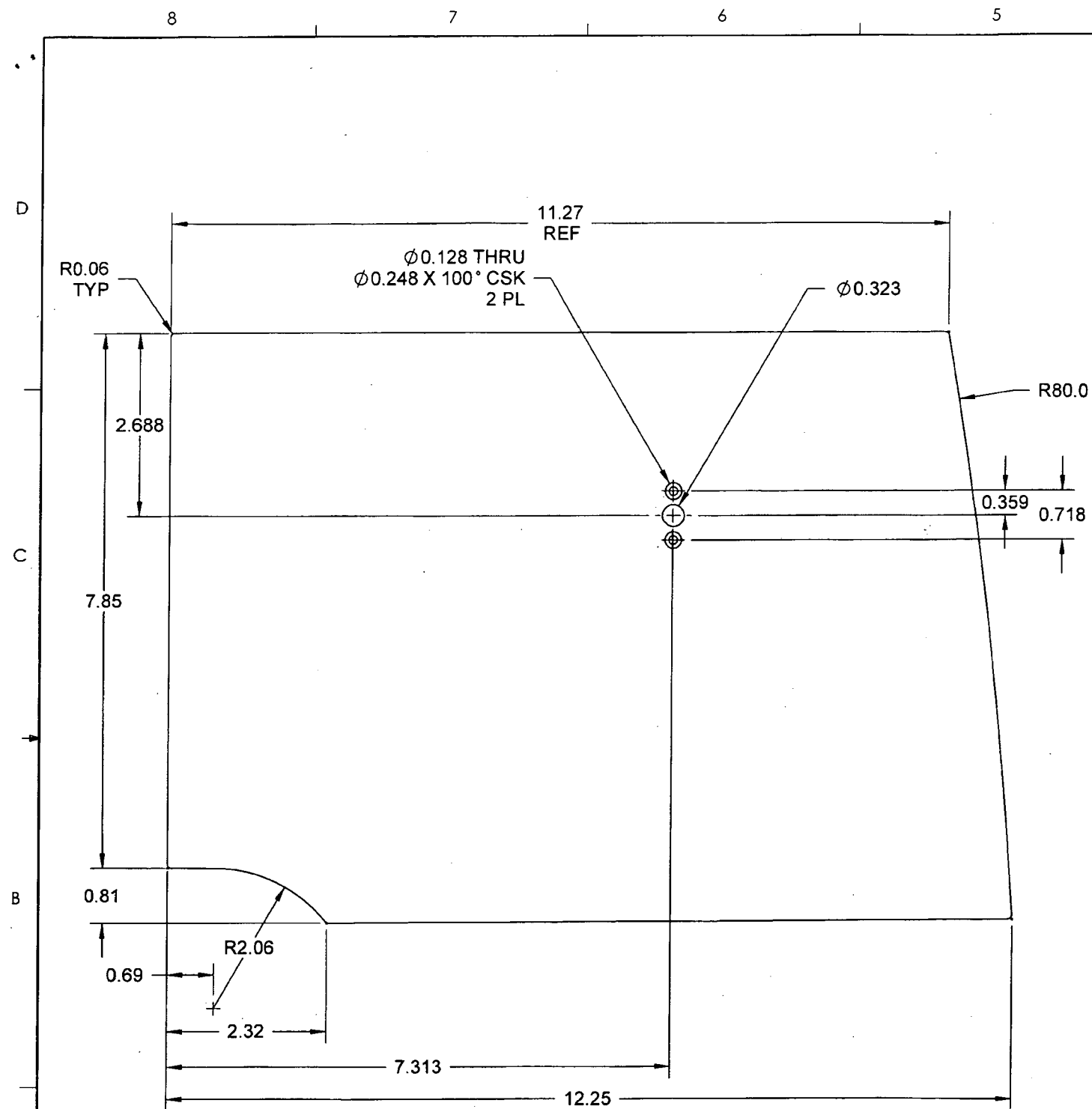
D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

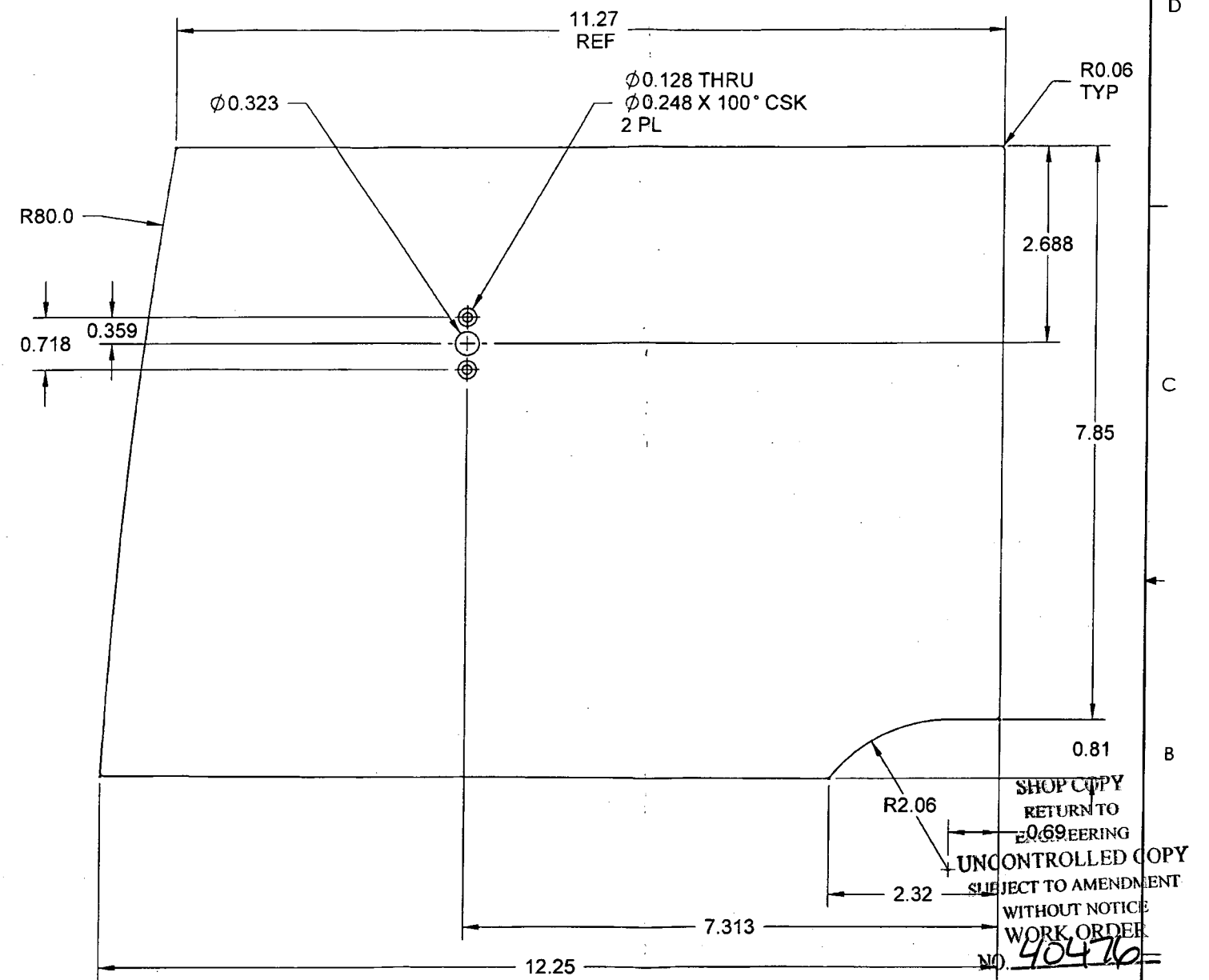
- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

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08-06-14

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MFG. APPR.		D3594	SHEET 4 OF 4
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